



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

Report

D412-711-101
Job Sheet 191916



Part No: D412-711-101

Job Qty: 1 pcs

Part Name: Replacement Vertical Reference Window



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/12/19

Job Tracking No:

Due Date: 3/15/19

Created By: Patrick Lussier

Type: Stock

Description:

Note: DWG REV C IPP Rev:A New Issue 06-02-01 JLM IPP Rev. B. Manufacture in-house 10/06/28 DL

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier Lead Time	
110	Purchasing	1 pcs	3/15/19	0.00	0.00	Purchasing - 1		MAR 26 2019
						Purchasing - 2		
						Purchasing - 3		
140	Packaging 2-1 - Receive - B4B	1 pcs	3/15/19	0.00	0.00	Packaging 2 - 1 - B4B		MAR 26 2019
						Packaging 2 - 2 - B4B		
						Packaging 2 - 3 - B4B		
						Packaging 2 - 5 - B4B		
						Packaging 2 - 4 - B4B		
						Packaging 2 - 6 - B4B		
						Packaging 2 - 7 - B4B		
						Packaging 2 - 8 - B4B		
						Packaging 2 - 9 - B4B		
						Packaging 2 - 10 - B4B		
						Packaging 2 - 11 - B4B		
						Packaging 2 - 12 - B4B		
						Packaging 2 - 13 - B4B		
						Packaging 2 - 14 - B4B		
						Packaging 2 - 15 - B4B		
						Packaging 2 - 16 - B4B		
						Packaging 2 - 17 - B4B		
						Packaging 2 - 18 - B4B		
						Packaging 2 - 19 - B4B		
						Packaging 2 - 20 - B4B		
						Packaging 2 - 21 - B4B		
						Packaging 2 - 22 - B4B		
						Packaging 2 - 23 - B4B		
						Packaging 2 - 24 - B4B		
						Packaging 2 - 25 - B4B		
						Packaging 2 - 26 - B4B		
						Packaging 2 - 27 - B4B		
						Packaging 2 - 28 - B4B		

ART

OSPAC

No: S161652

2-711-101

91916

Batch: S161652

Dart Aerospace Ltd.

1270 Aberdeen Street

Hawkesbury, ON K6A 1K7

CANADA

TEL.: 1 813 832-5200

Email: sales@dartaero.com

www.dartaerospace.com

TC STC SH92-30 Issue 3

TC STC SH92-54 Issue 4

TC STC SH9;

Plex 3/26/19 11:26 AM dart.lacelle.linde



Container No: S161652



Part: D412-711-101

Job No: 191916

Serial No/Batch: S161652

Revision:

Inspector:

Exp Date:

Instructions: TC STC SH92-30 Issue 2, TC STC SH92-54 Issue 4, TC STC SH9;

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				Packaging 2 - 29 - B4B	
				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
150	QC 6	1 pcs	3/15/19	0.00 0.00	QC 6 - 42
					QC 6 - 9
					QC 6 - 68
					QC 6 - 61
170	Packaging 3-1 - Stock - B4B	1 pcs	3/15/19	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B
					Packaging 3 - 19 - B4B
					Packaging 3 - 20 - B4B
					Packaging 3 - 21 - B4B
					Packaging 3 - 22 - B4B
					Packaging 3 - 23 - B4B
					Packaging 3 - 24 - B4B
					Packaging 3 - 25 - B4B
					Packaging 3 - 26 - B4B
					Packaging 3 - 27 - B4B
					Packaging 3 - 28 - B4B
					Packaging 3 - 29 - B4B
					Packaging 3 - 30 - B4B
					Packaging 3 - 31 - B4B
					Packaging 3 - 32 - B4B
					Packaging 3 - 33 - B4B
					Packaging 3 - 34 - B4B
					Packaging 3 - 35 - B4B
					Packaging 3 - 36 - B4B
175	DC - 1 - B4B	1 pcs	3/15/19	0.00 0.00	DC - 1 - B4B
					DC - 2 - B4B
180	QC 21 - FG	1 pcs	3/15/19	0.00 0.00	QC 21 - FG - 21
					QC 21 - FG - 70
					QC 21 - SA - 53
Part Op 110 - ISSUE P/O: _____ SUPPLIER: PLAS-TECH MANUFACTURE D412-711-101 AS PER DWG C Descriptions: OF C IS REQUIRED 140 - Receive & Inspect for Damage & Mat'l Certs 150 - QC6- All purchased or subcontracted products 170 - Identify as per dwg & Stock Location: _____ 175 - (Document Control) Photocopy blue file and create labels as per PPP D412-711-101 CHG002 180 - QC21- Final Inspection - Work Order Release					

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
D412-711-101P	Replacement Bubble Window	1 pcs (1 ea)	110-Purchasing	SIG1650 see attached 3082714 SIG1651
MACRLICS.236	Plexiglass G 0.236"	16 sf (16 ea)	110-Purchasing	
Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
110-Purchasing	D412-711-101P	1	0	0
	MACRLICS.236	16	288	0
Part Specifications				
Specifications could not be found.				

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Container Trace

S161652 Container Trace - Upstream													
Output Container No	Depleted Serial No	Status	Part No/Material	Operation Code	Op No	Depleted Date	Depleted Qty	Unit	Location	Serial No/Batch	Job No	Workcenter Code	Manufac Part N
S152010	S082724	Allocated	MACRLICS.236	Purchasing - SF	90	2/8/2019 9:05 AM	32.000	sf	Purchasing - 3	s082724	190400	Purchasing - 3	
S152010	S143805	Allocated	MACRLICS.236	Purchasing - SF	90	2/8/2019 9:05 AM	320.000	sf	Purchasing - 3	S143805	190400	Purchasing - 3	
S152010	FM134733.0	Allocated	MACRLICS.236	Purchasing - SF	90	2/8/2019 9:05 AM	10.000	sf	Purchasing - 3	M134733	190400	Purchasing - 3	
S161651	S152010	Stock	MACRLICS.236	Receive sf	100	3/12/2019 1:57 PM	16.000	sf	PLA002-VC	M134733/S082724/S143805			
S161652	S161651	Allocated	MACRLICS.236	Purchasing	110	3/12/2019 1:57 PM	16.000	sf	Purchasing - 1	M134733/S082724/S143805	191916	Purchasing - 1	
S161652	S161650	Allocated	D412-711-101P	Purchasing	110	3/12/2019 1:57 PM	1.000	pcs	Purchasing - 1	S161650	191916	Purchasing - 1	

S161652 Details											
Part No	Operation	Material	Status	Quantity	Net Weight	Add Date	Add By	Job No	Location	Serial No/Batch	
D412-711-101	Packaging 2-1 - Receive - B4B		WIP	1.000	0.000	3/12/2019 1:58 PM	Natasha Belanger	191916	Packaging 2 - 5 - B4B	S161652	

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Container History for S161652

Change Date	By	Job	Part	Rev	Operation	Material	Chg	Serial No/Batch	Gross	Tare	Net	Len	Qty	Location	Status	Accounting Job	Defect	Type
3/12/19 1:57 PM	Belanger, Natasha	191916	D412-711-101		Purchasing			S161652	0	0	0	0	0	Purchasing - 1	WIP			Cre
3/12/19 1:57 PM	Belanger, Natasha	191916	D412-711-101		Purchasing			S161652	0	0	0	0	1	Purchasing - 1	WIP			Proc
3/12/19 1:57 PM	Belanger, Natasha	191916	D412-711-101		Purchasing			S161652	0	0	0	0	1	Purchasing - 1	Allocated			Proc
3/12/19 1:57 PM	Belanger, Natasha	191916	D412-711-101		Purchasing			S161652	0	0	0	0	1	Purchasing - 1	Allocated			Prod
3/12/19 1:58 PM	Belanger, Natasha	191916	D412-711-101		Purchasing			S161652	0	0	0	0	1	Packaging 2 - 5 - B4B	Allocated			Loa
3/12/19 1:58 PM	Belanger, Natasha	191916	D412-711-101		Packaging 2-1 - Receive - B4B			S161652	0	0	0	0	1	Packaging 2 - 5 - B4B	Allocated			Rec
3/12/19 1:58 PM	Belanger, Natasha	191916	D412-711-101		Packaging 2-1 - Receive - B4B			S161652	0	0	0	0	1	Packaging 2 - 5 - B4B	Allocated			Proc
3/12/19 1:58 PM	Belanger, Natasha	191916	D412-711-101		Packaging 2-1 - Receive - B4B			S161652	0	0	0	0	1	Packaging 2 - 5 - B4B	WIP			Con



Dart Aerospace Ltd.
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PURCHASE ORDER

PO042482



Supplier: PLA002-VC
Plas-Tech
115 Applewood Crescent
Concord
ON
L4K 5C1 Canada
Phone: 416-736-0004
Fax: 416-736-0010

PO No: PO042482

PO Date: 2/1/19

Due Date: 3/15/19

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Phone:

Revision

Via: Ground

Pymt Terms: Net 60

Freight Terms:

Special Comments:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Items

Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	191914	D412-711-101P			Replacement Bubble Window As Per Dwg. D412-711-101 Rev. C	Firmed	-	3/15/19	1 pcs	0 pcs	1 pcs	\$472.82/pcs	\$472.82
							1 X	MAR 12 2019					
2	191915	D412-711-101P			Replacement Bubble Window As Per Dwg. D412-711-101 Rev. C	Firmed	-	3/15/19	1 pcs	0 pcs	1 pcs	\$472.82/pcs	\$472.82
							1 X	MAR 12 2019					
3	191917	D412-711-101P			Replacement Bubble Window As Per Dwg. D412-711-101 Rev. C	Firmed	-	3/15/19	1 pcs	0 pcs	1 pcs	\$472.82/pcs	\$472.82
							1 X	MAR 12 2019					
4		D412-711-101P			Replacement Bubble Window As Per Dwg. D412-711-101 Rev. C	Firmed	-	3/15/19	1 pcs	0 pcs	1 pcs	\$472.82/pcs	\$472.82
							1 X	MAR 12 2019					
Grand Total:												\$1,891.28	



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PURCHASE ORDER
PO042482

**Order Notes**

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Procurement Quality Clauses

- A005 RIGHT OF ENTRY
- A007 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION MAINTAINED BY SUPPLIER)
- A012 CHEMICAL AND PHYSICAL TEST REPORTS
- A016 PERSONNEL QUALIFICATION
- A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)
- A026 CERTIFICATION OF MATERIAL CONFORMANCE
- A041 QUALITY MANAGEMENT SYSTEM
- A042 DART NOTIFICATION BY SUPPLIER
- A043 RETENTION OF QUALITY DOCUMENT
- A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM
- A049 SUPPLIER AWARENESS

Plex 3/12/19 1:16 PM dart.Lussier.Patrick

PLAS-TECH
Think Plastics...

115 Applewood Crescent
Concord, ON, L4K 5C1
PLASTECHONLINE.COM

P- 416 736 0004
F- 416 736 0010

Packing Slip

Shipment Number: 34329
Shipment Date: 03/06/2019
BOL Number:
Customer Key: C1887
Salesperson: MIKE AUBE
Page Number: 1 of 1

B DART AEROSPACE LTD.
I 1270 ABERDEEN STREET
L HAWKESBURY ON K6A 1K7
L CA
Attn: DALE BATES
Buyer Contact: PATRICK LUSSIER

S DART AEROSPACE
H 1270 ABERDEEN STREET
I HAWKESBURY ON K6A 1K7
P CA
Attn: PATRICK LUSSIER

Purchase Order
42482
Carrier Account #
151793240

Sales Order
SO-027479

Incoterms
EX WORKS

Payment Method
COL
Tracking Number

Ship Via

~~FREIGHT~~

Item Number Revision	Description	Quantity Shipped	UOM
D412-711-101P Rev.: C	REPLACEMENT WINDOW AS PER DWG D412-711-101 REV C	1	EA
D412-711-101P Rev.: C	REPLACEMENT WINDOW AS PER DWG D412-711-101 REV C	1	EA
D412-711-101P Rev.: C	REPLACEMENT WINDOW AS PER DWG D412-711-101 REV C	1	EA
D412-711-101P Rev.: C	REPLACEMENT WINDOW AS PER DWG D412-711-101 REV C	1	EA
FREIGHT -	FREIGHT	1	EA

Number of Containers

Gross Weight

Shipped By

[Signature]

Certificate Of Conformance



Customer: DART AEROSPACE LTD

P.O. # 42482 ✓

SO # 027479

Part #	<u>D412-711-101P</u> ✓	Qty.	<u>1</u> ✓	Batch #	<u>-001</u>
Description	<u>REPLACEMENT WINDOW</u>	Material usage	<u>16 SQ FT</u>	Lot#	<u>DART0118</u>
					<u>S152010</u>
Part #	<u>D412-711-101P</u> ✓	Qty.	<u>1</u> ✓	Batch #	<u>-002</u>
Description	<u>REPLACEMENT WINDOW</u>	Material usage	<u>16 SQ FT</u>	Lot#	<u>DART0118</u>
					<u>S152010</u>
Part #	<u>D412-711-101P</u> ✓	Qty.	<u>1</u> ✓	Batch #	<u>-003</u>
Description	<u>REPLACEMENT WINDOW</u>	Material usage	<u>16 SQ FT</u>	Lot#	<u>DART0118</u>
					<u>S152010</u>
Part #	<u>D412-711-101P</u> ✓	Qty.	<u>1</u> ✓	Batch #	<u>-004</u>
Description	<u>REPLACEMENT WINDOW</u>	Material usage	<u>16 SQ FT</u>	Lot#	<u>DART0118</u>
					<u>S152010</u>
Part #		Qty.		Batch #	
Description		Material usage		Lot#	
Part #		Qty.		Batch #	
Description		Material usage		Lot#	
Part #		Qty.		Batch #	
Description		Material usage		Lot#	
Part #		Qty.		Batch #	
Description		Material usage		Lot#	

Note: All parts are not identified as meeting QSI044.

By: AS
(Approved QA Signatory)

Date: MAR 6, 2019

COFC # 104

Page: 1 of 1

△ MIN THICKNESS = 0.046
EXCEPT WHERE SHOWN

7.2 MIN THICKNESS = 0.043 △

△ MIN THICKNESS = 0.065
THIS FACE & REGION ONLY

△ MIN THICKNESS = 0.076
THIS FACE & REGION ONLY

△ MIN THICKNESS = 0.052
EXCEPT WHERE SHOWN

NOTES:

- 1) MATERIAL: PLEXIGLAS G CLEAR CAST ACRYLIC SHEET PER LP-391 TYPE 1 GRADE C OR POLYCAST II CLEAR ACRYLIC SHEET PER MIL-P-5425, 0.236 THICK (STOCK, REF. DART SPEC. M-ACRYLIC-S.236)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE P/N "D412-711-101" & B/N "BXXXXX" ON THE INSIDE SURFACE OF THE BUBBLE WINDOW FLANGE, WITHIN 0.25" OF BUBBLE. USE 0.125" LETTERS TO MAX. DEPTH OF 0.005"
- 7) WEIGHT: 8.0 lbs
- 8) VACUUM FORMING: PER FOLIO FTA077 USING DT9640 MOLD AND DART QSI 022

D412-711-101 REPLACEMENT WINDOW

C	CHG WALL DIMS PER TR-D412-711-1 REV. B	CP	16.04.21
B	REMOVED 1.73" DIM (ZN B4-1). SEE PREVIOUS REV. FOR DETAILS. 2.00 WAS 1.98 (ZN B3-1) REF CIR12-6	SFM	12.12.24
A	NEW ISSUE	MB	10.08.28
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	CP		
CHECKED	NO	DRAWING NO.	REV. C
MFG. APPR.	198	D412-711-101	SHEET 1 OF 1
APPROVED	198	TITLE	SCALE
DE APPR.	198	REPLACEMENT WINDOW	NTS
DATE	16.04.21	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR TRANSMITTED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

SCRAP → Acceptable per Eng review
 15/4/21
 RELEASED
 2017-02-07
 ECN 17-512

CRUSHED IN

0.106 MIN UT

0.205 CAL PER
0.193 UT

Entered: LR Date: Oct 30/19



NCR No. 19-7657 **WORK ORDER NON-CONFORMANCE / ROUTE UPDATE**

Route update only ☐

Job: <u>191916</u>	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☒	DEPARTMENT/PROCESS			
Part No. <u>D412-711-101</u>		Skid-tube ☐ Machining ☐ Large Fab ☐	Cross tube ☐ Small Fab ☐ Finishing ☐	Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐	Engineering ☐ Water Jet ☐ Supplier ☒ Quality ☐

Date: <u>19/4/18</u>	Sequence #: <u>150 QCB</u>	QTY Affected: <u>1</u>	MRB (QSI042) <u>IMP 12</u> <u>19/4/18</u>
----------------------	----------------------------	------------------------	--

Description Work Order Deviation - Part is 15" high and was placed in 13" box. Top section of bubble was buckled in box, however the shape returned after removal from the box.	Disposition Acceptable. No sign of cracking, stretching, distortion, or buckling. Material is naturally flexible and small amounts of bending will not damage material.	Completed By <u>19/4/18</u> Lead hand / Supervisor <u>19.04.18</u> QC / QA Coordinator DAS 68 APR 24 2019
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Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☒ Material ☒ Product Improvement ☐ Process Improvement ☐ Human Factors ☒	FAULT CATEGORY <table border="0"> <tr> <td>☐ Pressure/Forced</td> <td>☐ Contamination</td> <td>☐ Power Loss/Surge</td> <td>☐ Positioned Wrong</td> </tr> <tr> <td>☐ Bending</td> <td>☐ Misaligned/off center</td> <td>☐ Folio/Program</td> <td>☐ Outside Tolerance</td> </tr> <tr> <td>☒ Crushing</td> <td>☐ BOM/Route</td> <td>☐ Grain Direction</td> <td>☐ Drawing</td> </tr> <tr> <td>☐ Cracks</td> <td>☐ Broken/Damage/Defect</td> <td>☐ Weld</td> <td>☐ Finish</td> </tr> <tr> <td>☐ Crimp/Kink/Ripple/Wave/Twist</td> <td>☐ Incomplete/Unclear Instructions</td> <td>☐ Wrong Stock Pulled</td> <td>☐ Part Lost/Missing</td> </tr> <tr> <td>☐ Marks/Chatter</td> <td>☐ Drill Holes</td> <td>☐ Out of Sequence</td> <td>☐ Misread</td> </tr> <tr> <td>☐ Mislabeled</td> <td>☐ Fit/Function</td> <td>☐ Off-set/Set-up</td> <td></td> </tr> </table>	☐ Pressure/Forced	☐ Contamination	☐ Power Loss/Surge	☐ Positioned Wrong	☐ Bending	☐ Misaligned/off center	☐ Folio/Program	☐ Outside Tolerance	☒ Crushing	☐ BOM/Route	☐ Grain Direction	☐ Drawing	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Finish	☐ Crimp/Kink/Ripple/Wave/Twist	☐ Incomplete/Unclear Instructions	☐ Wrong Stock Pulled	☐ Part Lost/Missing	☐ Marks/Chatter	☐ Drill Holes	☐ Out of Sequence	☐ Misread	☐ Mislabeled	☐ Fit/Function	☐ Off-set/Set-up	
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Other/Details:																													